

Work Order ID 67242

Monday, March 14, 2011 10:14:39 AM

BLUE

Page 1

Item ID: D206-628-021BL

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step LH, Blue

Start Date: 3/14/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: *CX*Date: *11/03/14*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D206-628	F								

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels as per PPP D206-628-021 CHG 003

*81105176**HJ for BG 11-4-28*

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

11/4/29 SD 20

120

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

*81105176**x2**44*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67242

Monday, March 14, 2011 10:14:40 AM



Page 2

Item ID: D206-628-021BL

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step LH, Blue

Start Date: 3/14/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-628-021 Location: _____ PPP Rev: _____ <i>R</i>								
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

*Europe**11/5/30**ME*
11-0526

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____





Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Monday, March 14, 2011 10:14:36 AM

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2724-041 		Manufactured	No			110	Each	0.0000	1	2			
206L Step Assembly													
D2731-7 		Manufactured	No			110	Each	42.0000	4	8 Yx			
Mounting Lug													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST470				42					
				61653				1					
				62929				41					
D2732-030 		Manufactured	No			110	Each	18.0000	8	16			
Rubber Cushion													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST409				18					
				65395				18					
D3394-043 		Manufactured	No			110	Each	60.0000	4	18 3x			
Lug Assembly													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST475				60					
				62930				30					
				62976				30					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 67242

Parent Item: D206-628-021BL

Parent Item Name: Heli-Access-Step LH, Blue

Start Date: 3/14/2011

Required Date: 3/25/2011

Start Qty: 2.00

Required Qty: 2.00

AN4-14A

Purchased

No

110

Each

259.0000

4

8

1x



Bolt



M117313

[Handwritten signature]

Location

Loc Qty

Loc Code

ST357

259

113359

3

114752

1

116419

9

116786

146

116914

100

7

AN4-15A

Purchased

No

110

Each

330.0000

8

16



Bolt



M117313

[Handwritten signature]

Location

Loc Qty

Loc Code

ST308

316

116786

316

ST358

14

114784

9

115108

5

AN960JD416

NAS1149D0463J

Purchased

No

110

Each

30.0000

12

24



Washer



M117065

[Handwritten signature]

Location

Loc Qty

Loc Code

ST300

24

113288

24

ST356

6

115622

6

Monday, March 14, 2011 10:14:37 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, March 14, 2011 10:14:37 AM

Page 3

Work Order ID: 67242

Parent Item: D206-628-021BL

Parent Item Name: Heli-Access-Step LH, Blue



Start Date: 3/14/2011

Required Date: 3/25/2011

Start Qty: 2.00

Required Qty: 2.00

MS21042E4

Purchased

No

110

Each

4,370.000

12

1 24



Nut



11/4/29 *[Signature]* 20

Location

Loc Qty

Loc Code

ST300

4370

1123143

2

115589

10

115621

20

116188

2338

116823

2000

24

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.1 D206-628-011/-012/-021/-022/-031/-032 REGULAR DART HELI-ACCESS- STEPS™ PARTS LIST

Qty -011	Qty -012	Qty -021	Qty -022	Qty -031	Qty -032	Part Number	Description
X						D206-628-011	206 A/B STEP INSTALLATION LH
	X					D206-628-012	206 A/B STEP INSTALLATION RH
		X				D206-628-021	206 L/L1/L3/L4 STEP INSTALLATION LH
			X			D206-628-022	206 L/L1/L3/L4 STEP INSTALLATION RH
				X		D206-628-031	407 STEP INSTALLATION LH
					X	D206-628-032	407 STEP INSTALLATION RH
1						D2721-041	STEP ASSEMBLY LH
	1					D2721-042	STEP ASSEMBLY RH
		1		1		D2724-041	STEP ASSEMBLY LH
			1		1	D2724-042	STEP ASSEMBLY RH
2	2			4	4	D2731-3	MOUNTING LUG
2	2	4	4			D2731-7	MOUNTING LUG
8	8	8	8	8	8	D2732-0301	RUBBER CUSHION
2	2			4	4	D3394-041	MOUNTING LUG
2	2			4	4	*D3394-1	*MOUNTING LUG
4	4			8	8	*MS35489-93	*GROMMET
2	2	4	4			D3394-043	MOUNTING LUG
2	2	4	4			*D3394-3	*MOUNTING LUG
4	4	8	8			*MS35489-93	*GROMMET
4	4			4	4	AN4-13A	BOLT
4	4	4	4	4	4	AN4-14A	BOLT
4	4	8	8	4	4	AN4-15A	BOLT
12	12	12	12	12	12	AN960JD416	WASHER
12	12	12	12	12	12	MS21042L4	NUT (OR MS21042-4)

*DENOTES THAT PART IS INCLUDED IN ASSEMBLY ABOVE

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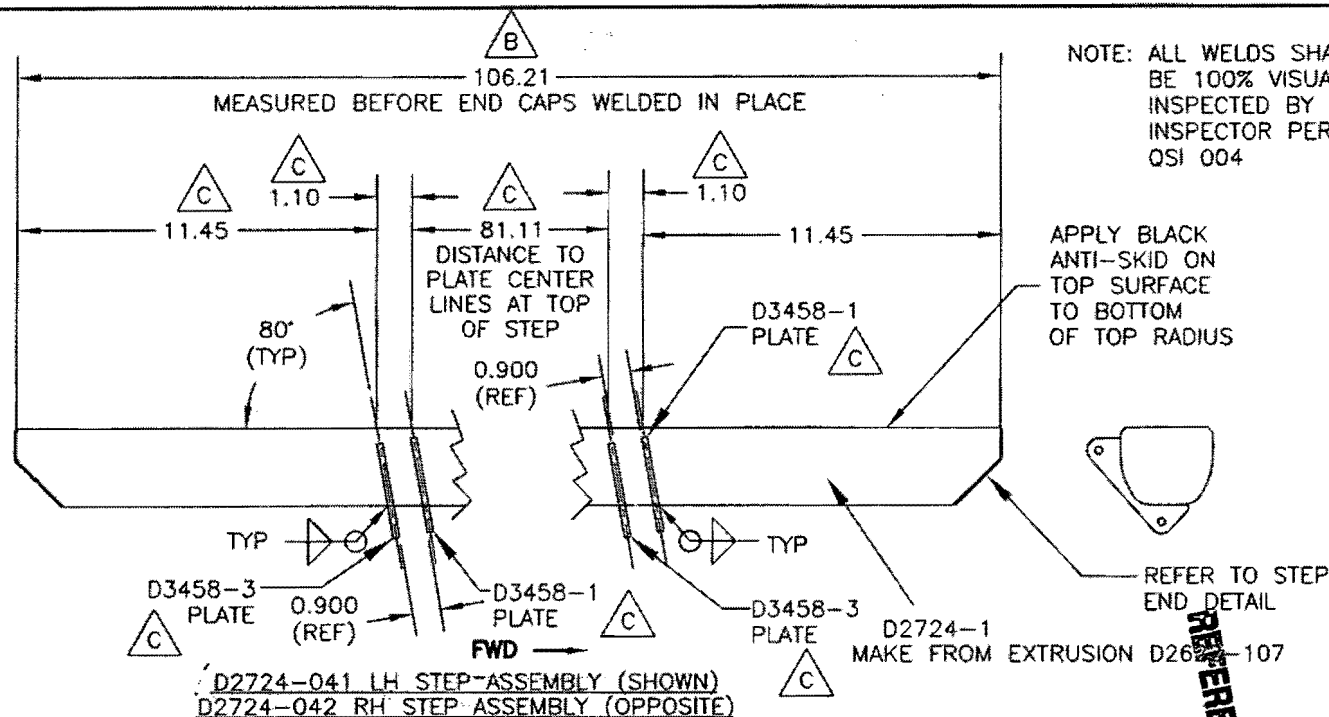
Revision: F

Date: 08.02.07

DART

RELEASED
05.11.14

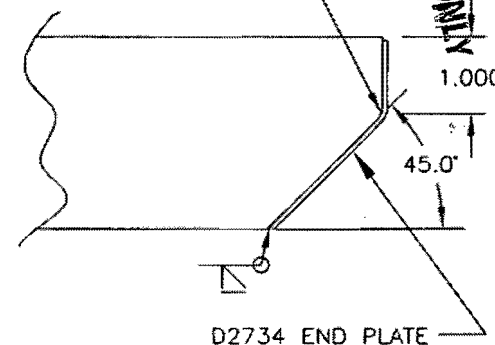
NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004



— REFER TO STEP
END DETAIL

D2724-1
MAKE FROM EXTRUSION D2691-107

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE



D2734 END PLATE

TYPICAL STEP END DETAIL
NOT TO SCALE

D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY - 041	QTY - 042	PART NUMBER	DESCRIPTION
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
2) WELD PER DART QSI 004
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
4) ALL DIMENSIONS ARE IN INCHES
5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DESIGN KE	UPDRAIN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED HA	APPROVED HA	DRAWING NO. D27724	REV. C SHEET 1 OF 1
DATE 05.09.19	TITLE 206L/407 STEP ASSEMBLY		SCALE N150
A	97.12.04	NEW ISSUE	
B	98.10.19	UPDATED WELD DETAIL REVISED TOLERANCES	
C	05.09.19	RE-DESIGN, ADD D3458-1/-3	

